

Sorstu

Work Order ID 62953

Thursday, October 14, 2010 12:37:33 PM



Page 1

Item ID: D3393-1

Accept



Setup

Start



Revision ID:

Item Name: Battery Lock Casing

Stop



Start Date: 10/14/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-10-14 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3393	Rev A
-------	-------

100



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 1.500" x 1.500" x 3.125" long

0.00

ark 10/11/23

10

8

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

ark 10/11/23

10

9

120



QC2- Inspect parts off machine FAI/FAIB

QC

0.00

ark 10/11/23

10

8

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.A 10/11/23

10

X



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> M 10/11/23

10

X



HandFinish

Memo

0.00

Hand Finishing

150

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

12:00

OVEN TEMPERATURE:

FINISH TIME:

12:30

10 AM 11-01-27

W/O:		WORK ORDER CHANGES							
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Page 3

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Cust Item ID:

Required Date: 10/14/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

11/01/27

QC

Quality Control

170

Identify as per dwg & Stock Location:
487

0.00

11/01/28

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

11/01/31

QC

Quality Control

Memo

0.00

11/01/25
(10)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, October 14, 2010 12:37:37 PM

Page 1

Work Order ID: 62953



Parent Item: D3393-1



Parent Item Name: Battery Lock Casing

Start Date: 10/14/2010

Required Date: 10/14/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A□05.02.18□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	13.1762	0.2708	2.850526			

6061-T6 Bar 1.50 x 1.50



Location	Loc Qty	Loc Code
MAT10	13.1762	
107244	1	
→ 107432	12.1762	

2.850 out 10/11/23

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DART AEROSPACE LTD		Work Order:	62953
Description: Battery Lock Casing		Part Number:	D3393-1
Inspection Dwg: D3393	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+0.010/-0.000	Ø.751	—		Vern	ML-7
0.625	+0.010/-0.000	.626	—		“	“
Ø1.250	+/-0.010	Ø.1247	—		“	“
1.088	+/-0.010	1.082	—		“	“
Ø0.734	+/-0.010	Ø.743	—		“	“
2.658	+/-0.010	2.657	—		“	“
1.550	+/-0.010	1.547	—		“	“
0.125 x 45°	+/-0.010 x 0.5°	Ø1.100x45°	—		“	“
1.50	+/-0.030	1.487	—		“	“
0.750	+/-0.010	.741	—		“	“
Ø1.050	+/-0.010	1.060	—		“	“
Ø1.000	+/-0.010	Ø1.066	—		“	“
0.338	+/-0.010	.339	—		“	“
0.563	+/-0.010	.560	—		“	“
0.100	+0.000/-0.010	.099	—		“	“
3.00	+/-0.030	3.003	—		“	“
1.500	+/-0.010	1.497	—		“	“
0.375	+/-0.010	.375	—		“	“
1.25	+/-0.030	1.252	—		“	“
0.125	+/-0.010	.120	—		“	“
30°	0.5°	30°	—		Comb-square	ML-CBR

Measured by:	G.W.	Audited by:	G.A.	Prototype Approval:	N/A
Date:	10/11/23	Date:	10/11/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	
B	08.11.28	Tolerances revised	KJ/EC	DA

W/O:		WORK ORDER CHANGES					
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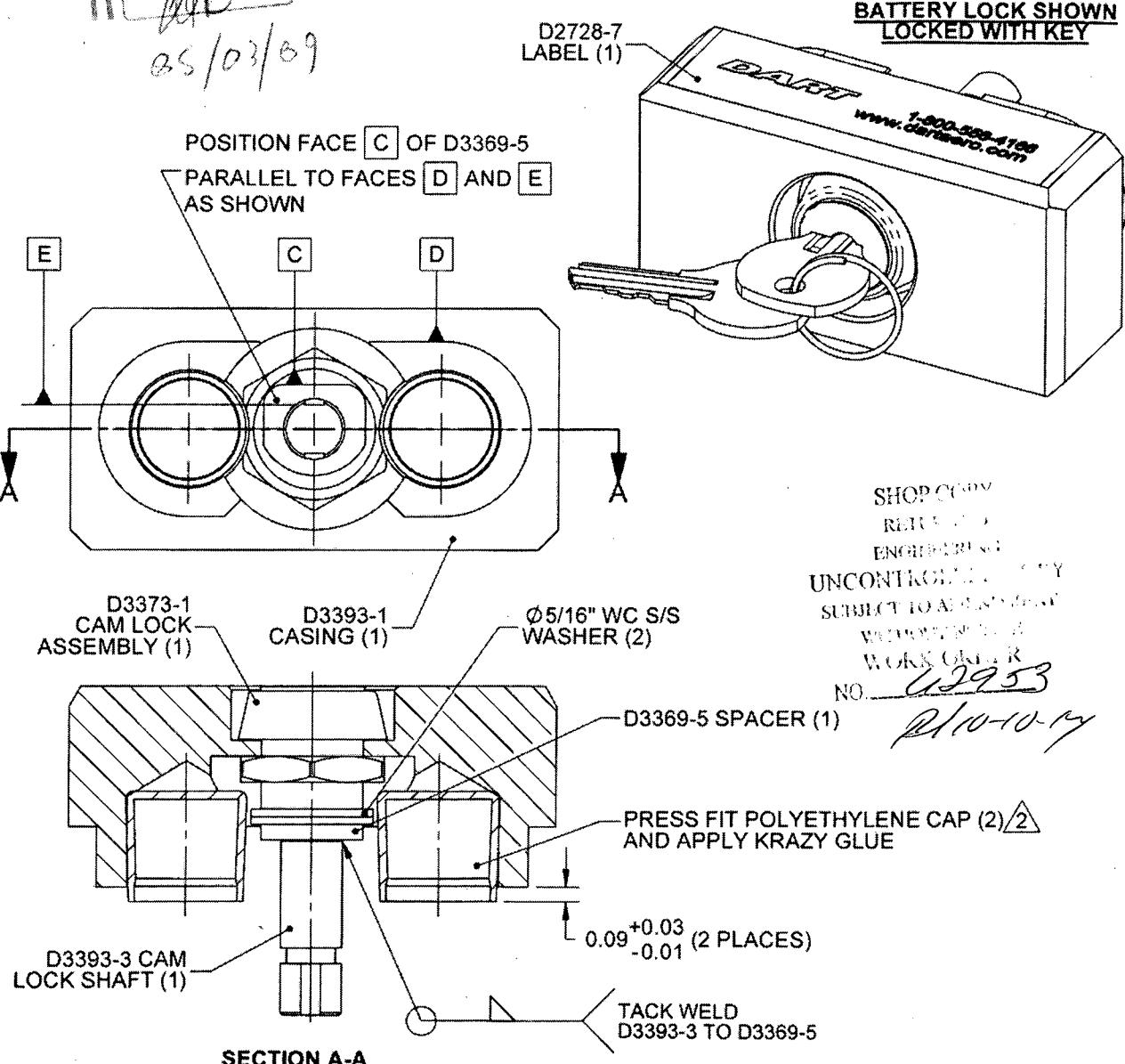
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NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED MS	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

~~RELEASED~~
R [initials]
05/03/09



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-Carr, P/N 9567K21

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3393	SHEET 2 OF 3

DATE

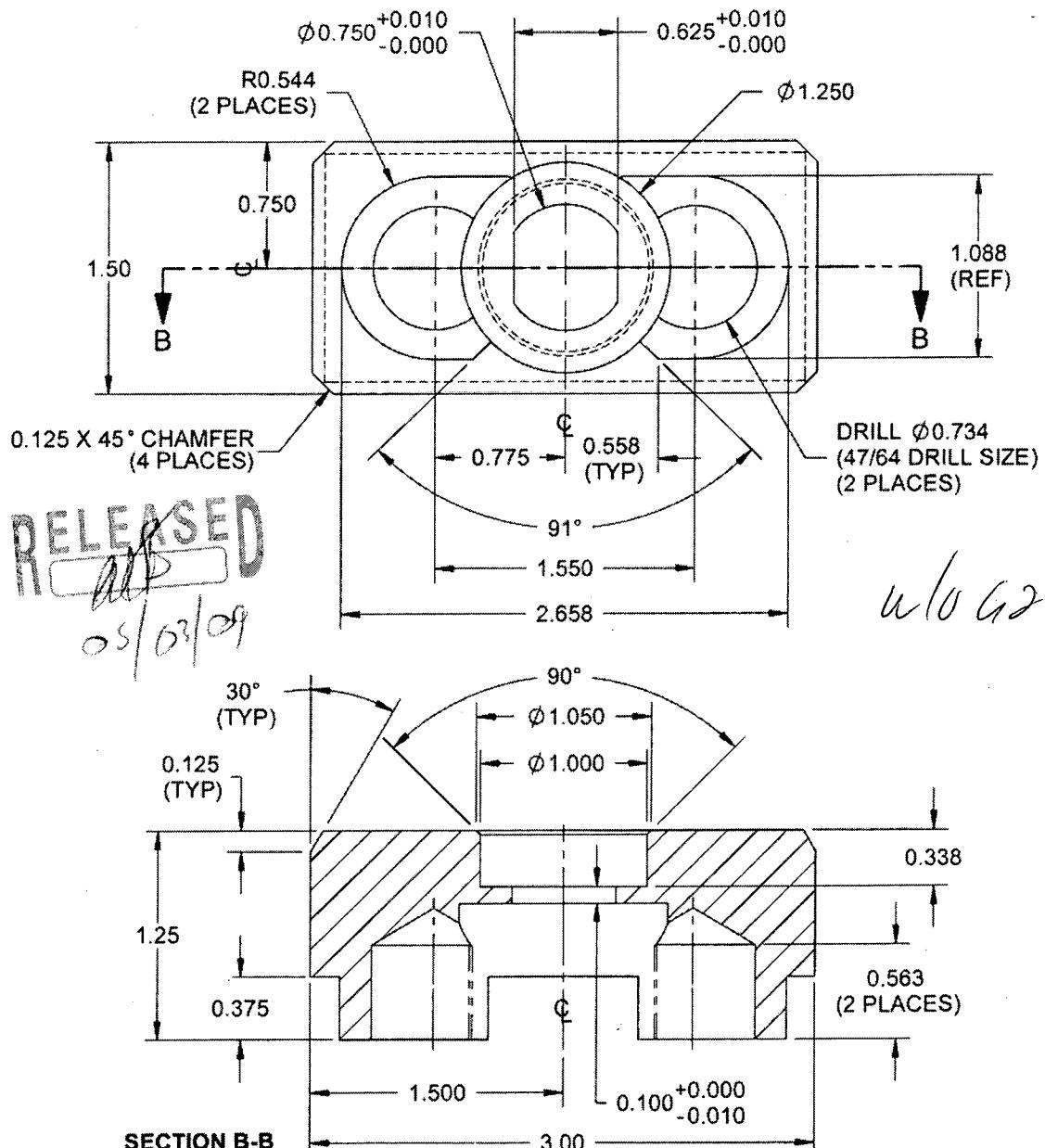
05.02.09

TITLE

BATTERY LOCK

SCALE

1:1



D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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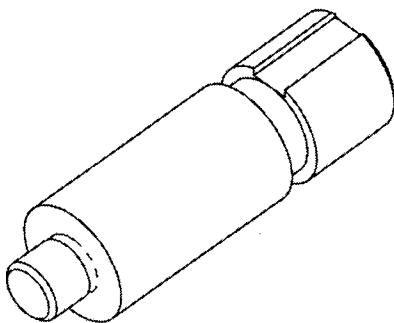
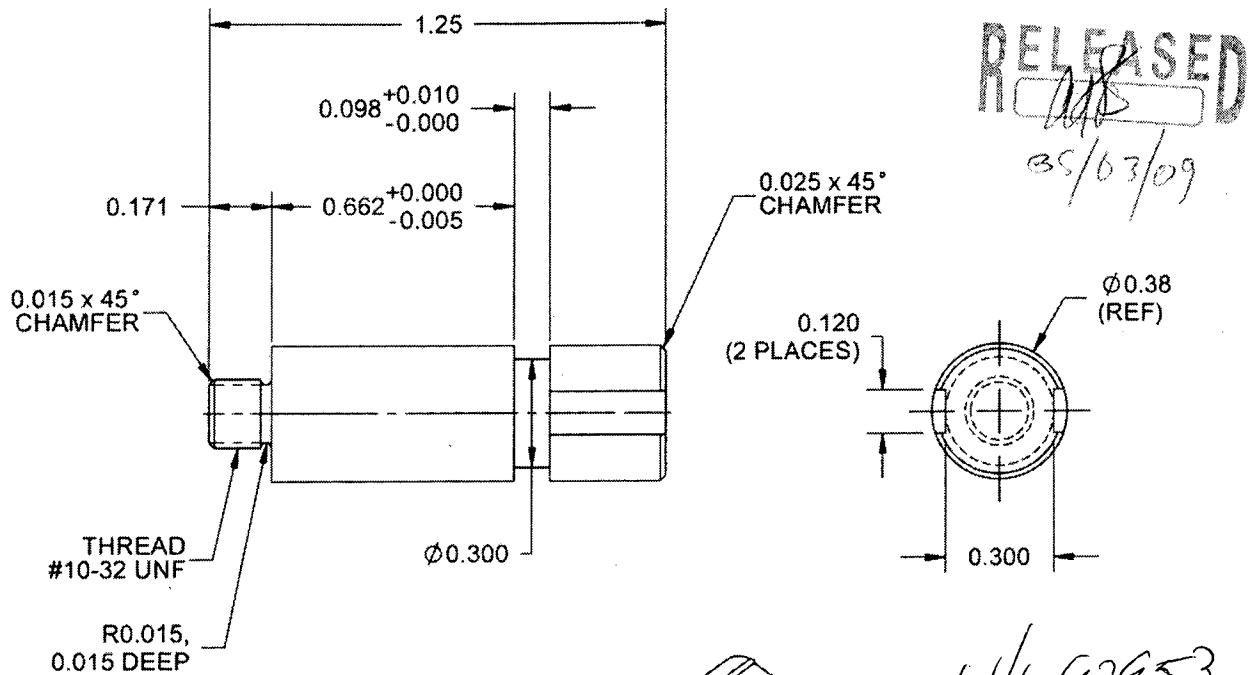
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DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TK</i>	APPROVED <i>PL</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O:		WORK ORDER CHANGES					
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